

Work Order ID 50968



Page 1

July 28, 2009 11:48:04 AM

Item ID: D3011-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rappel

Start Date: 31/07/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 05/08/2009 Req'd Qty: 10.00



Customer:

Reference: 31/07/2009

28.

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3011	Rev B	

100



BAND SAW

0.00

10

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks: 26.625"

H.A 09/07/28

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA129

Folio Rev: B

Dwg Rev: B

H.A 09/08/01
88 09/08/04

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

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need + attached report

e 9/08/11 10

C2 09/08/11 10

C2 09/08/11 10

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Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

132



QC5- Inspect part completeness to step on W/O

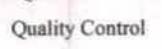
0.00

ml

09 08 11



QC



Quality Control

140



Chemical Conversion Coat per QSI005 4.1

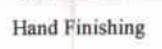
0.00

gl

09-08-12



HandFinish



Memo

0.00

Hand Finishing

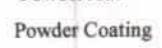
150



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat



Memo

0.00

Powder Coating

START TIME: 2:30 pm
 OVEN TEMPERATURE: 320 °C
 FINISH TIME: 3:00 pm ~

gl

09-08-12



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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

=> S 09/08/13

0.00



QC

Memo

Quality Control

170

Identify as per dwg & Stock Location: 6-A

0.00

Packaging

Memo

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

C 09/08/13

0.00

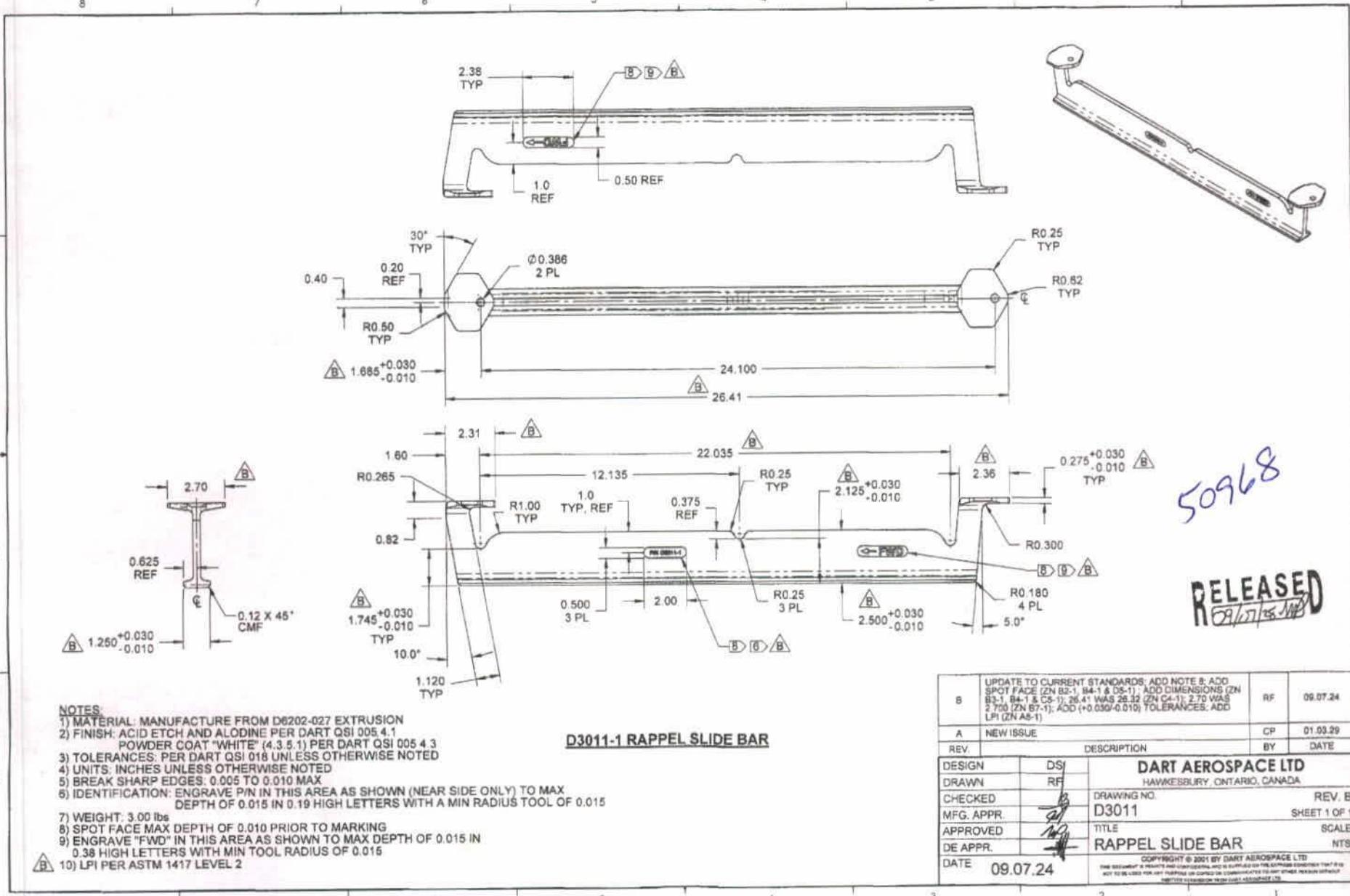
DART AEROSPACE LTD	Work Order:	50968
Description: Rappel	Part Number:	D3011-1
Inspection Dwg: D3011 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.A	Audited by:	JL	Prototype Approval:	N/A
Date:	09/08/02	Date:	09/08/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





LIQUID PENETRANT TEST REPORT

P- 14945

CLIENT	Dart Aerospace			DATE	Aug-10-2009		
ATTENTION	Linda Chantel			ACUREN JOB NO.	188-09-001484		
ADDRESS	1270 18TH DEEN ST. HAWKESBURY ON. K6H-1K7			PO/WO NO.	10194		
PROJECT	F.P.I. ON MACHINED PARTS - AND CROSS TUBES			WORK LOCATION	HAWKESBURY		
ITEM(S) EXAMINED	44 STUDS. 20 RAPPELS 7 CROSS TUBES. + 12 STUDS.			ACCEPTANCE STD.	ASME 1417 REV./DATE 2007		
JOB DESCRIPTION	PROCEDURE NO. LT-0002 REV./DATE			TECHNIQUE NO.	LT-TECH-2 REV./DATE		
PART NO.	MATERIAL STAINLESS STEEL			THICKNESS	1/8 INCH		
SCOPE	WET FLUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL						
TEST DETAILS							
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED		
FAMILY BRAND	MAGNAFLUX			BLACK LIGHT S/N 16459	OUTPUT > 1000 μ W/CM ²	<input type="checkbox"/> AMBIENT < 2 fc	
PENETRANT	2L 67	MINIMUM DWELL TIME	45 ¹⁰ MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER	H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	LAB BINO		
DEVELOPER	SKD 52	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE		
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		DEC. 8 - 2009		
TEST SURFACE							
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input type="checkbox"/> CLEAN BARE METAL		
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F	<input type="checkbox"/> -4°C/20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F			
RESULTS- (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)							
14 Pcs STUDS - W.O. 509 33 ✓ 30 Pcs STUDS - W.O. 507 21 ✓ 12 Pcs STUDS - W.O. 509 32. ✓ 10 Pcs RAPPEL - W.O. 509 67 ✓ 10 Pcs RAPPEL - W.O. 509 68 ✓ 1 CROSSTUBE - W.O. 510 8 3 ✓ 1 CROSSTUBE - W.O. 510 8 4 ✓ 1 CROSSTUBE - W.O. 510 8 5 ✓ 1 CROSSTUBE - W.O. 508 7 3 ✓ 1 CROSSTUBE - W.O. 508 2 7 ✓ 1 CROSSTUBE - W.O. 508 0 0 ✓ 1 CROSSTUBE - W.O. 508 2 6 ✓				ml 09 08 11 To BUFF AND EXAMINE - INDICATION - 6 ITEMS TO EXAMINE AFTER BUFFING - OTHER Pcs FOUND ACCEPTABLE TO STANDARD.			
Scope of Services							
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.							
Standard of Care							
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.							
SIGNATURES							
CLIENT REPRESENTATIVE	CHANTAL LAUDIE		PRINT	Chantal Laudie		SIGNATURE	DTR # E - 20068
TECHNICIAN (SIGNATURE):	<i>Mike Jetterson</i>		PRINT			REPORT REVIEWED BY:	
NAME (PRINT):	Mike Jetterson		1 ST TECHNICIAN	2 ND TECHNICIAN		NAME	INITIALS
CGSB LEVEL	SNT LEVEL		CGSB LEVEL	SNT LEVEL			
CGSB REG. NO	6066		CGSB REG. NO				